

Work Order ID 130521

130521

Page 1

Friday, March 13, 2015 12:57:04 PM

Item ID: D4543-4 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Retainer, RH Outer (Sloe)
 Start Date: 3/13/2015 Start Qty: 8.00 *8* Cust Item ID:
 Required Date: 3/13/2015 Req'd Qty: 8.00 *8* Customer:
 Reference:

Approvals: Process Plan: MW Date: 15-03-13 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4543	B

100 0.00

100

Waterjet

FLOW CNC Waterjet

6061.032

Memo

1- Cut D4543-3F as per dwg

Prog rev: B

Dwg rev: B

2- Deburr

0.00

⑧

DC 15/03/21

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

⑧

DC 15/03/21

Work Order ID 130521

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Page 2

Item ID: D4543-4

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Retainer, RH Outer (Sloe)

Start Date: 3/13/2015 Start Qty: 8.00

8

Cust Item ID:

Required Date: 3/13/2015 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp
DAS
38
9-89

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

MAR 23 2015

130

0.00

130

Small Fab

Memo

0.00

Small Fab

FORM ON BEAD ROLLER (DT9787)

***MAKE ONE AND ENSURE IT'S MADE AS PER DWG BEFORE
MAKING QTY REQUIRED ON W/O***

8 FF MAR 24 2015

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

DAS
38
9-89

MAR 24 2015

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130521

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Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Retainer, RH Outer (Sloe)

Stop *NS2*

Start Date: 3/13/2015 **Start Qty:** 8.00

g

Cust Item ID:

Required Date: 3/13/2015 **Req'd Qty:** 8.00

g

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
---------	--------	-----------

Accept Qty	Reject Qty	Reject Number	Insp. Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

160

QC7-Inspect Chemical Conversion Coat

0.00

160

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: S7 (63) 0.00

0.00

170

Packaging

Memo

0.00

Packaging

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130521

Page 4

Item ID: D4543-4 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Retainer, RH Outer (Sloe)
Start Date: 3/13/2015 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 3/13/2015 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

MLJ 15-04-01

① 15.4-1

Picklist Print

Friday, March 13, 2015 12:57:07 PM

Page 1

Work Order ID: 130521

130521

Parent Item: D4543-4

D4543-4

Parent Item Name: Retainer, RH Outer (Sloe)

Start Date: 3/13/2015

Required Date: 3/13/2015

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP revA 12.01.12 New Issue EC verified by:DD
REV:B 12.02.24 as per dwg reva DD verf:EC
13.04.23 as per dwg revB DD verf:JLM
IPP
IPP REV:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased		No		100	sf	249.5213	1.144	10			

M6061T6S 032

6061-T6 Sheet 0.032"

12/15/03/21

Location

Loc Qty

Loc Code

MAT021

249.5213

m130387

61.6667

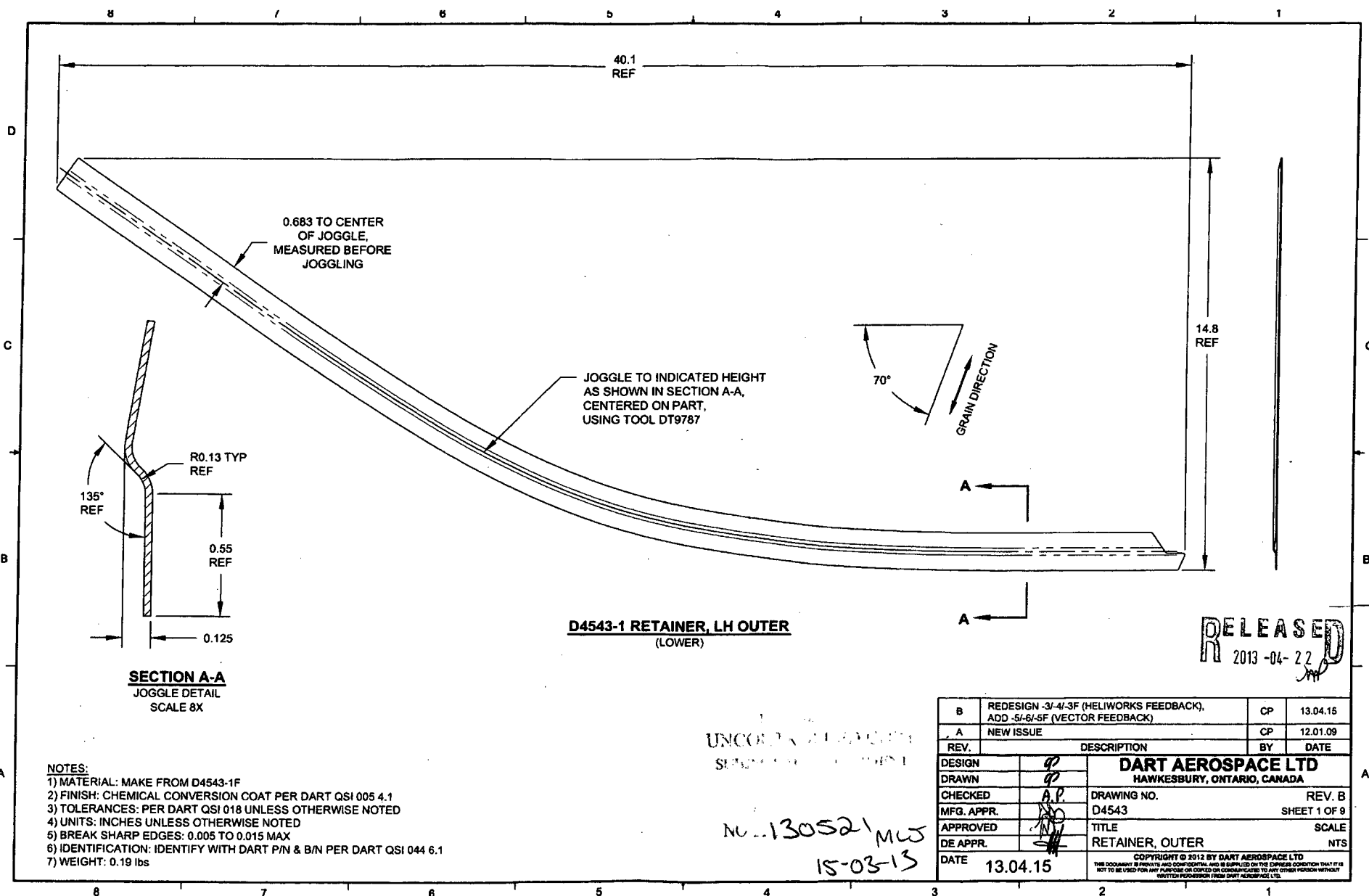
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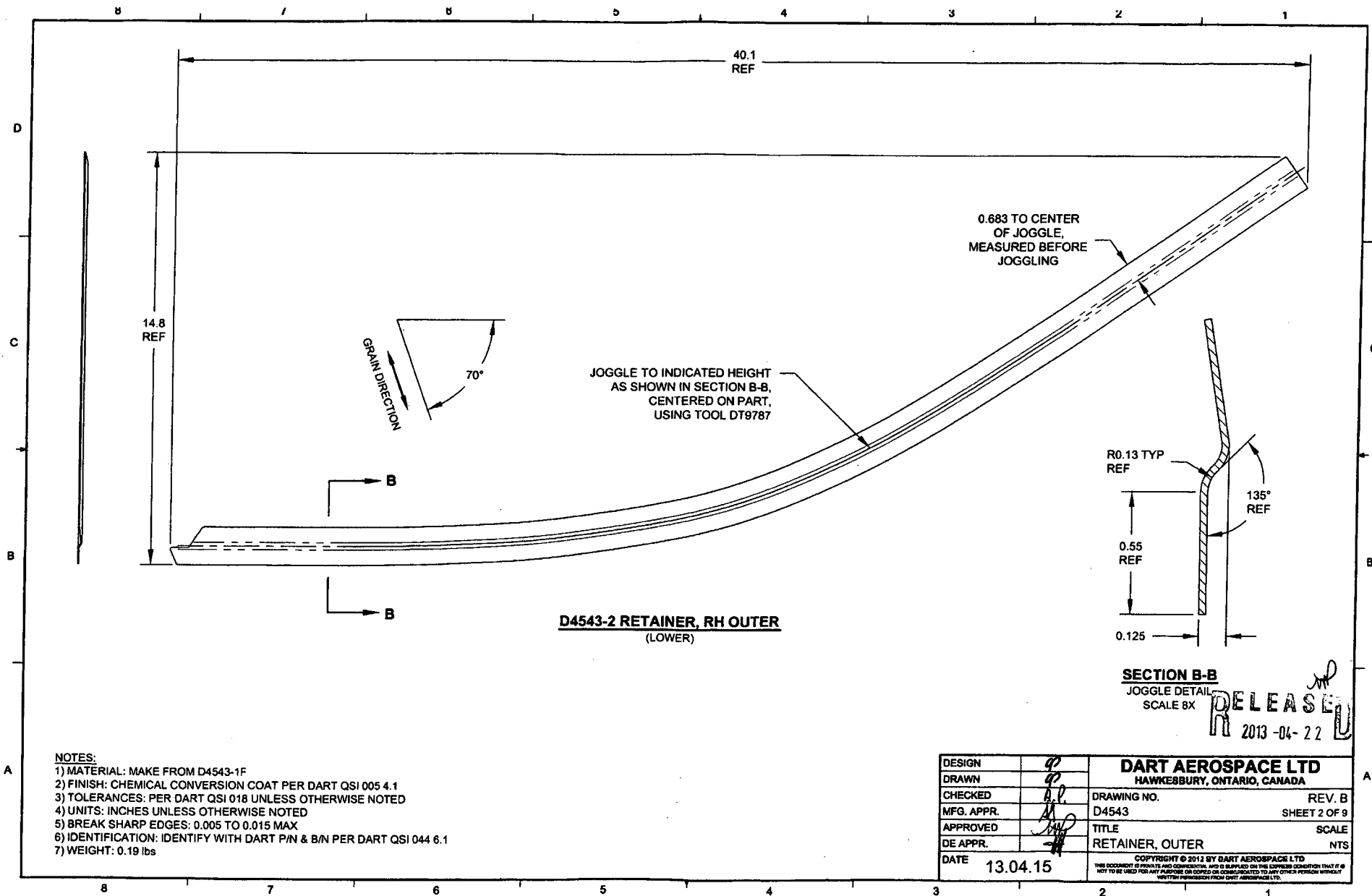
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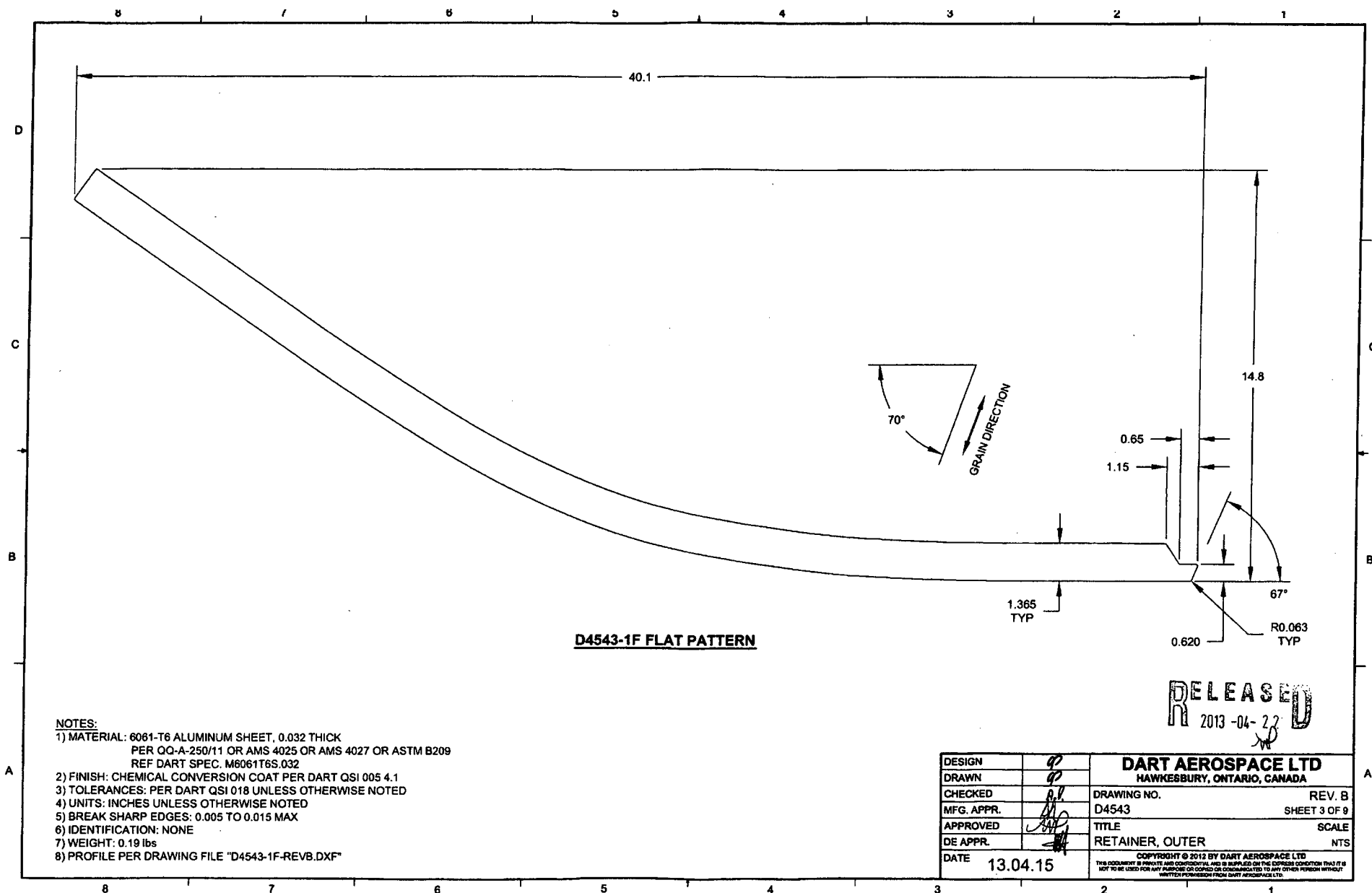
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129.4

12





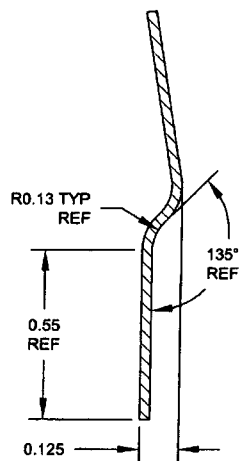


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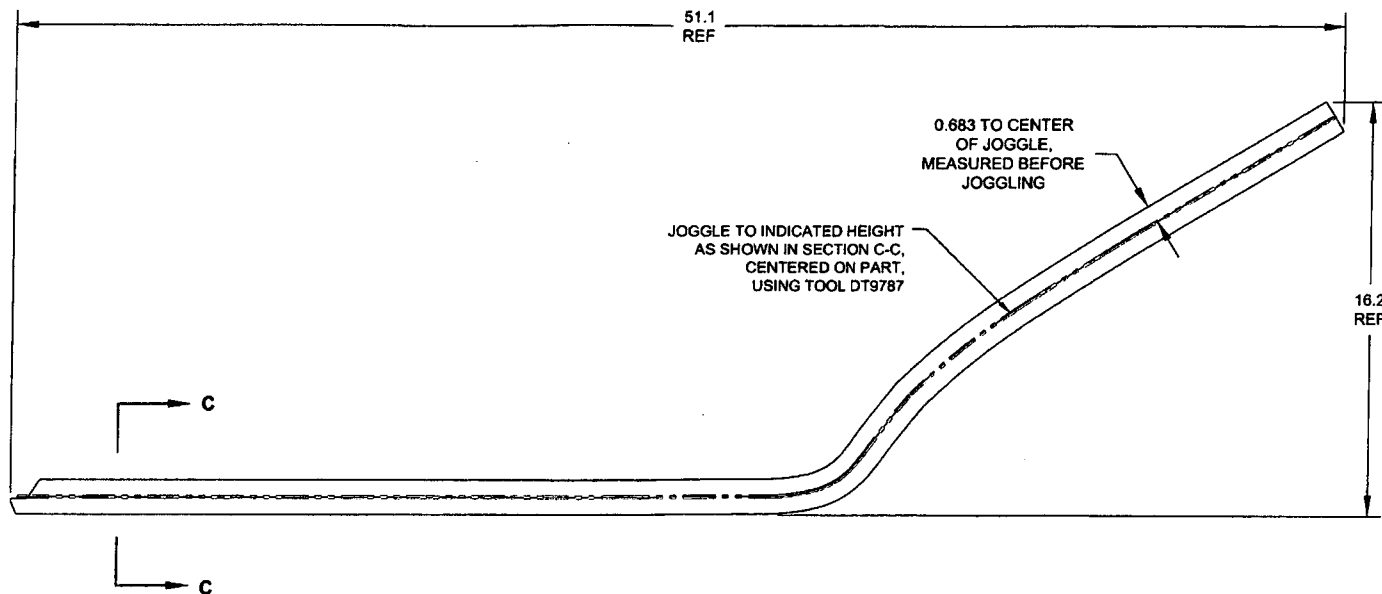
- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.19 lbs
- 8) PROFILE PER DRAWING FILE "D4543-1F-REV.B.DXF"

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2013-04-22

DESIGN	92	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	92		
CHECKED	92	DRAWING NO.	REV. B
MFG. APPR.	92	D4543	SHEET 3 OF 9
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DE APPR.	92	RETAINER, OUTER	NTS
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SECTION C-C
JOGGLE DETAIL
SCALE 12X



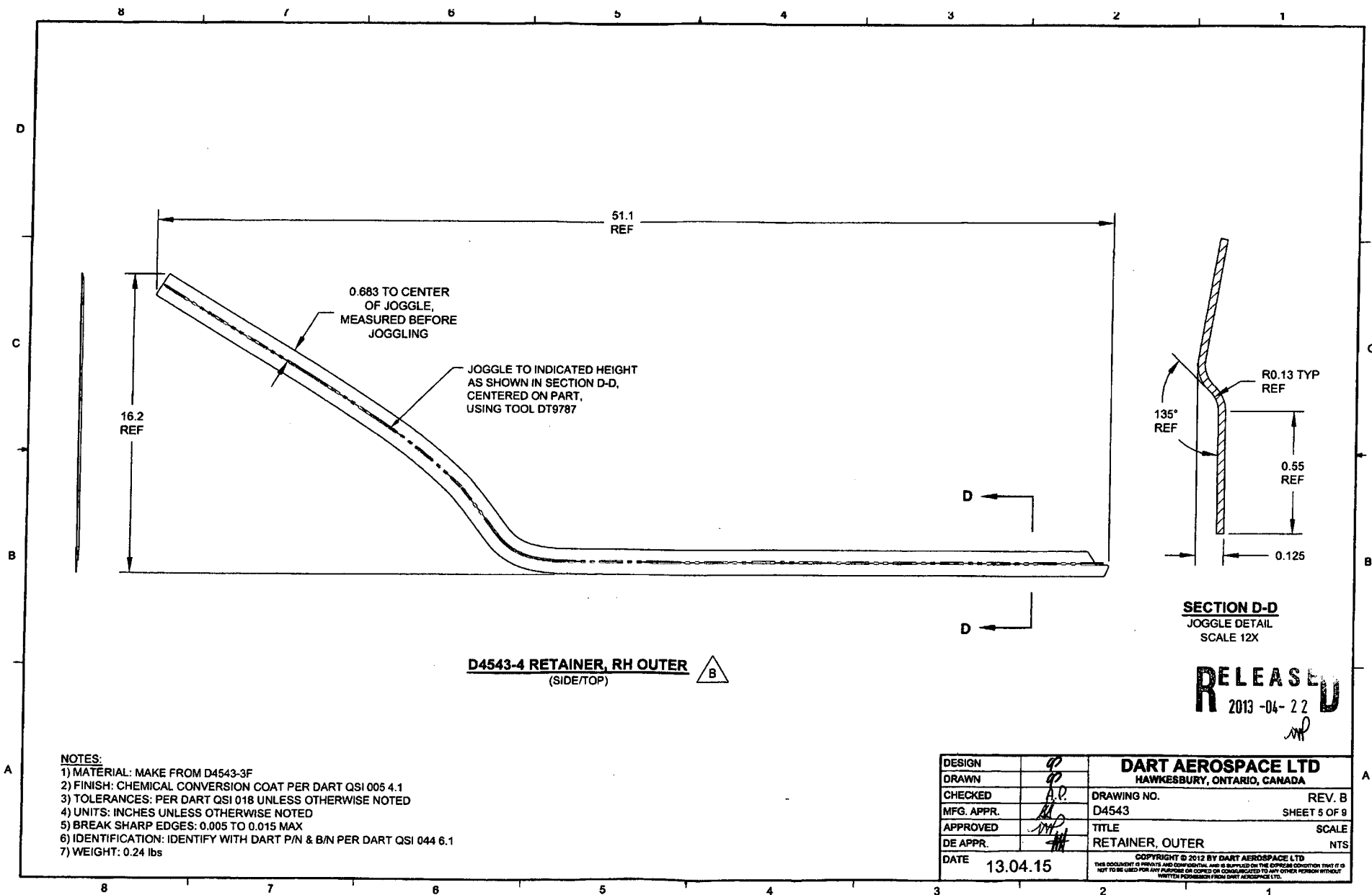
D4543-3 RETAINER, LH OUTER
(SIDE/TOP) B

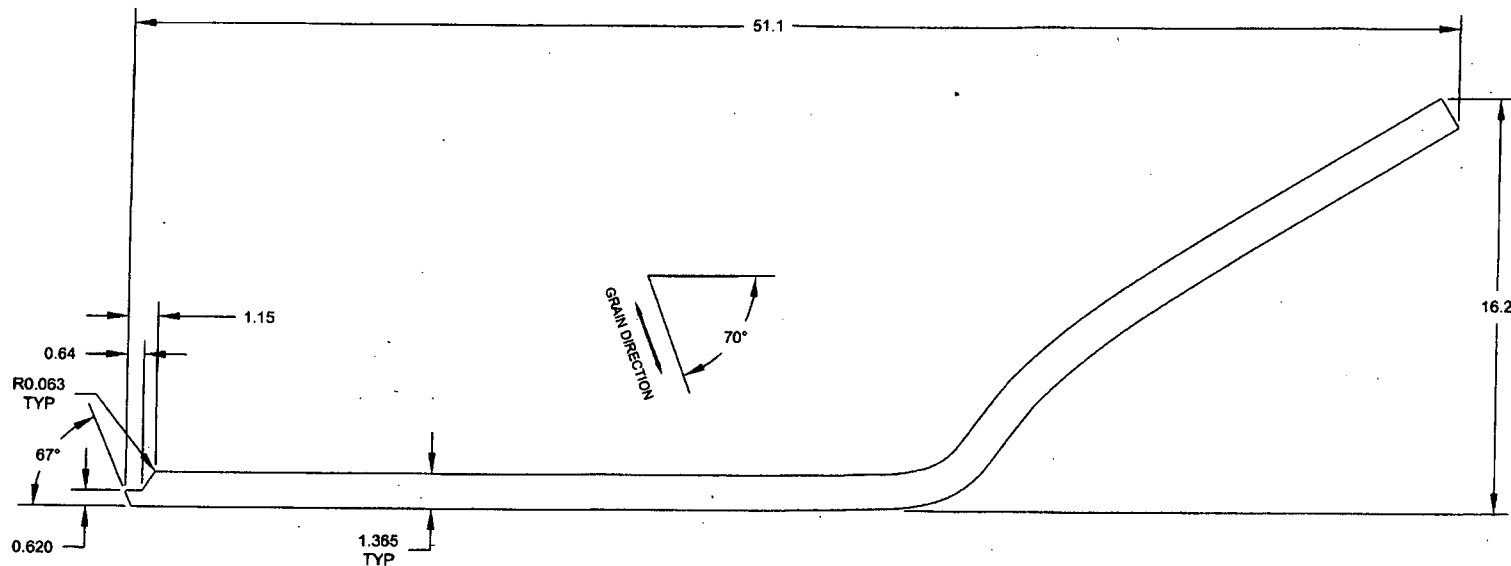
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- 1) MATERIAL: MAKE FROM D4543-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1
- 7) WEIGHT: 0.24 lbs

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D4543-3F FLAT PATTERN

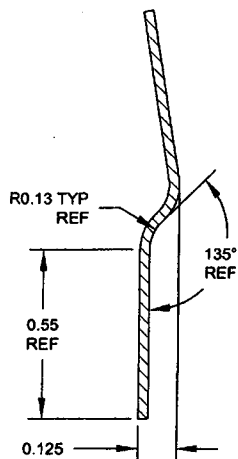


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2013-04-22

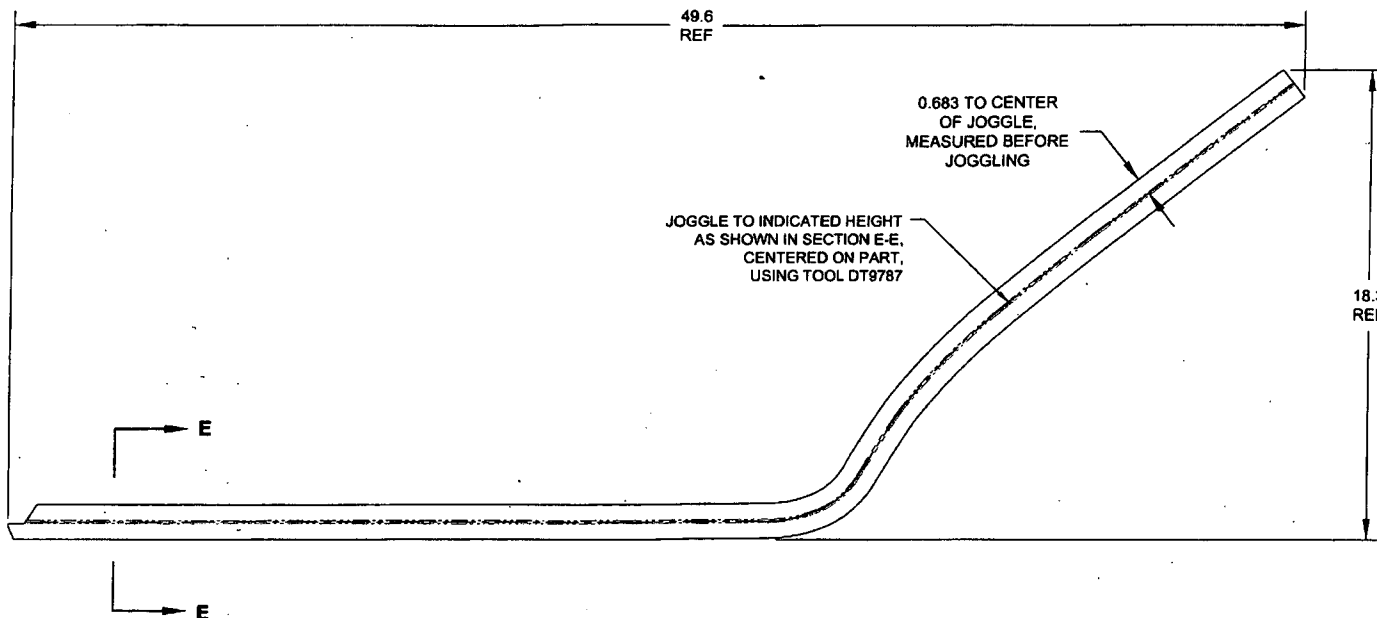
NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.24 lbs
- 8) PROFILE PER DRAWING FILE "D4543-3F-REVB.DXF"

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SECTION E-E
JOGGLE DETAIL
SCALE 12X



D4543-5 RETAINER, LH OUTER
(SIDE/TOP)

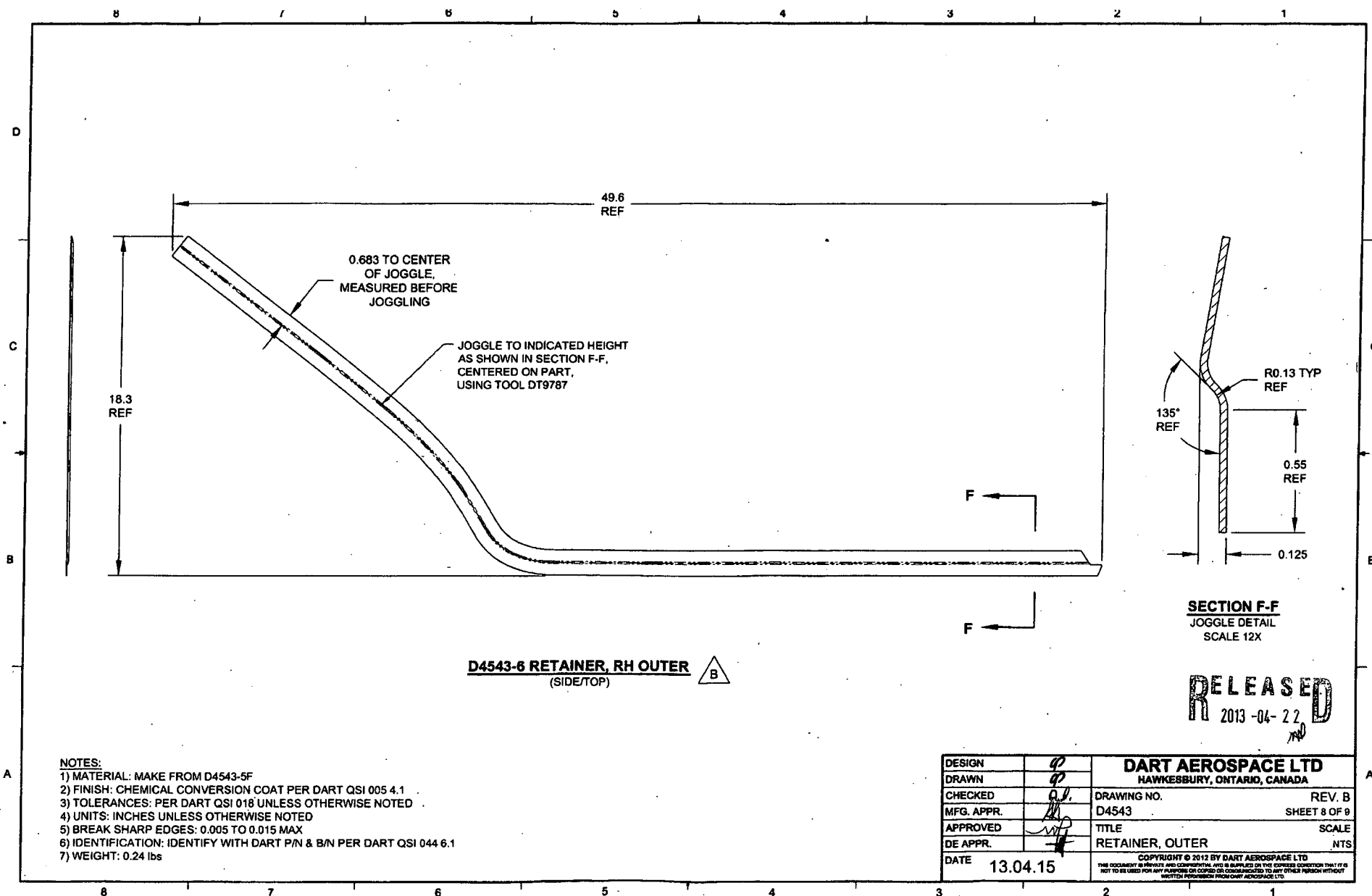


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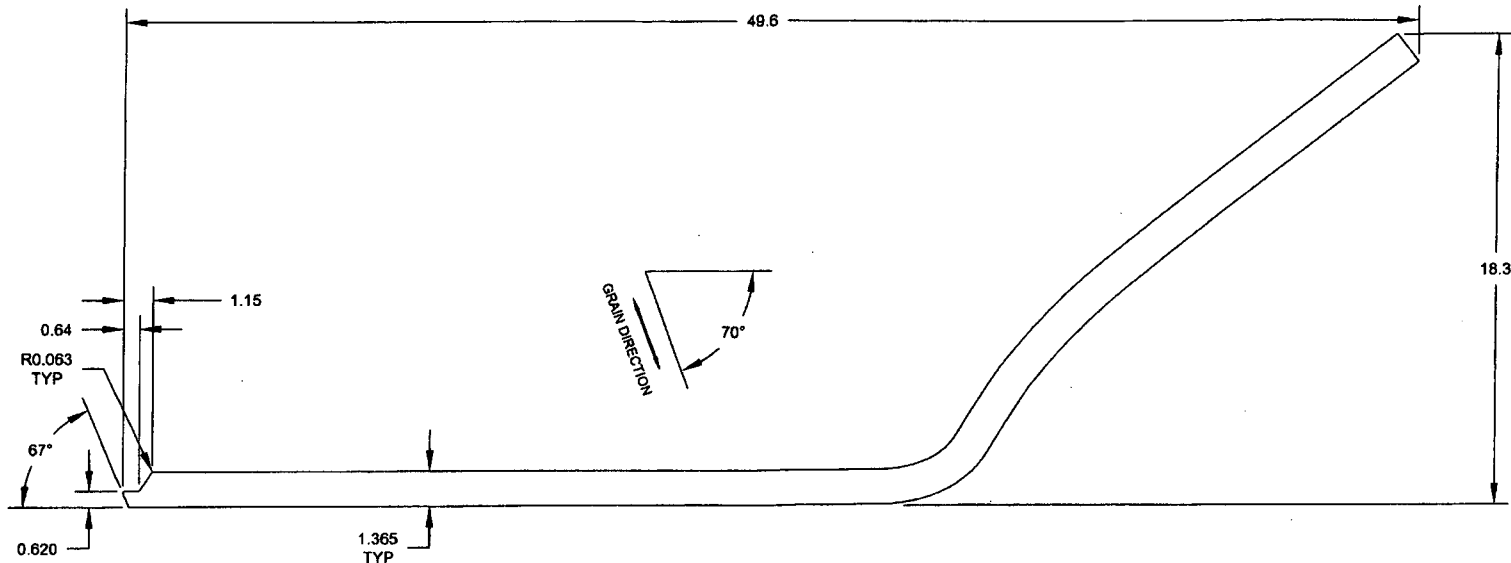
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- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1
- 7) WEIGHT: 0.24 lbs

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D4543-5F FLAT PATTERN



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R 2013-04-22 D

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